

<b>DART AEROSPACE LTD.</b>	<b>Work Order :</b>	23787
<b>Description:</b> 206 Saddle, Inboard, Right Side	<b>Part Number:</b>	D2666-2
<b>Drawing:</b> D2666 Rev. B	<b>Qty:</b>	4

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required RF 02/09/16</i>	<i>HA</i>	05.07.08	4
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length (D6101-001) RF 02/09/16 Batch No: B20981	<i>BE</i>	05.07.12	4
3	HAAS	Program part number and batch number.	<i>BE</i>	05.07.12	4
4	QC	Inspect part number and batch number are programmed correctly.	<i>J.L</i>	05.07.13	4
5	HAAS	Fixturing W/O No. <del>_____</del> Fixturing Inspection last completed _____ by _____	<i>W/L</i>		
6	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	<i>me</i>	05/07/14	4
7	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	<i>me</i>	05/07/14	4
8	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	<i>me</i>	05/07/14	4
9	LAGUN	Machine Keyway and inspect per attached dimension sheet	<i>me</i>	05/07/14	4
10	METAL	Deburr	<i>me</i>	05/07/14	4
11	QC	Inspect Level 1	<i>me</i>	05/07/14	4
12	QC	Inspect Level 8	<i>me</i>	05/07/14	4
13	METAL	Acid etch and Alodine as per QSI 005 4.1	<i>EP</i>	05/07/14	4
14	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	<i>FF</i>	05.07.14	4
15	QC	Inspect Level 3	<i>FC</i>	05/07/14	4
16	STORES	Pack in foam, identify and stock	<i>PD</i>	05-07-23	4
17	EXPEDITING	Close Work Order Job Cost / Part <i>110.15500 05/08/02 (4)</i>	<i>DL</i>	05/07/29	4
		<i>73.83</i>	<i>IG</i>	05/08/13	4

Rev	Date	Change	Created By	Approved
A	97.07.24	New Issue		
B	98.09.08	Inspection levels, added powder coat	KS	
C	00.11.01	Removed P/O for Powder Coat - in house process	EC	<i>h.</i>

RELEASED

DEC 18 2000

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
							17	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

NCR: Yes No DQA: PD Date: 05/04/02  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23787</b>
<b>Description: 206 Saddle, Inboard, Right side</b>	<b>Part Number:</b>	<b>D2666-2</b>
<b>Inspection Dwg: D2666 Rev. B</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.122	0.124	0.122	0.123		
B	0.100	0.140		0.125	0.125	0.124	0.127		
C	0.100	0.140		0.120	0.120	0.120	0.120		
D	0.210	0.230		0.216	0.222	0.222	0.221		
E	1.245	1.255		1.250	1.249	1.250	1.250		
F	1.245	1.255		1.249	1.249	1.250	1.250		
G	5.990	6.010		6.004	6.003	6.004	6.003		
H	0.510	0.515		0.512	0.512	0.513	0.512		
I	1.674	1.684		1.679	1.680	1.678	1.679		
J	2.495	2.505		2.501	2.499	2.499	2.498		
K	0.257	0.262	DT8683	✓	✓	✓	✓		
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		0.239	0.238	0.238	0.238		
N	0.100	0.140		0.111	0.118	0.118	0.118		
O	0.540	0.560		0.548	0.550	0.548	0.550		
P	0.490	0.510		0.500	0.502	0.502	0.497		
Q	3.609	3.619		3.615	3.613	3.611	3.610		
R	2.470	2.510		2.497	2.497	2.498	2.495		
S	0.240	0.270		0.249	0.249	0.248	0.249		
T	0.100	0.180		0.143	0.147	0.144	0.144		
U	0.313	0.318	DT8686	✓	✓	✓	✓		
V	1.125	1.145		1.125	1.145	1.145	1.143		
W	1.565	1.585	DT8695 A/B	✓	✓	✓	✓		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>me</i>
Date:	05/07/14

Audited by:	<i>ES</i>
Date:	05/07/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	<i>RF</i>

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jul 08, 2005  
01:32 pm

Work Order No : 0023787  
Project Name : D2666-2  
Project For : WK528  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2666-2  
Description : Saddle, RH, Fwd,Aft, In  
Manufactured : Yes  
Amount Req'd : 4  
Amount Done : 0  
Start Date : 07-08-05  
Est Finish Date : 07-23-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00